



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D3573-8

Job Sheet 194657



Part No: D3573-8

Job Qty: 8 pcs

Part Name: Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Due Date: 5/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		5/27/19	0.00	0.10	Bandsaw - 1		DJP 19-05-14
110	HAAS 4 Axis - B4B	8 pcs		5/27/19	0.21	2.87	HAAS - 1 - B4B		DJP 19-05-14
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	8 pcs		5/27/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Handfinish - 1-1 Chemical- B4B	8 pcs		5/27/19	0.00	0.31	Handfinish - 1 - 1 - B4B		BEI 19-05-21



Container No: S181275



Part: D3573-8

Job No: 194657

Serial No/Batch: S181275

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 05/14/19

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				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 3 Grey Sand - B4B	8 pcs	5/27/19	0.00 0.25	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BFB 19-05-23
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	8 pcs	5/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	BK HUM 19-05-23
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	8 pcs	5/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	GA12290 MAY 27 2019
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	5/27/19	0.00 0.00	QC 21 - SA - 21	21 MAY 29 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Cut blank 3.500" long

Descriptions: 110 - (HAAS CNC Vertical Machine), Machine as per Folio FA679 and Dwg D3573

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

M138839 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: 11:30 TEMP: 320° Finish: 12:00

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____), LOCATION : GA

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X02.500	6061-T6 Bar .500 X 2.50	2.3360 ft (.292 ea)	100-Bandsaw - 1	S174839

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.500X02.500	2	21	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Adapter	3.320Inches $\pm$ 0.030	3.350 3.290	3.313	
2	Adapter	2.750Inches $\pm$ 0.030	2.780 2.720	2.747	
3	Adapter	0.360Inches $\pm$ 0.030	0.390 0.330	0.356	
4	Adapter	1.600Inches $\pm$ 0.010	1.610 1.590	1.600	
5	Adapter	0.480Inches $\pm$ 0.030	0.510 0.450	0.476 ⁵	
6	Adapter	2.380Inches $\pm$ 0.030	2.410 2.350	2.374	
7	Adapter	1.420Inches $\pm$ 0.010	1.430 1.410	1.420	
8	Adapter	1.813Inches $\pm$ 0.010	1.823 1.803	1.810 ⁵	
9	Adapter	0.209Inches + 0.005 - 0.001	0.214 0.208	0.210	Diameter
10	Adapter	0.201Inches + 0.005 - 0.001	0.206 0.200	0.202	Diameter
11	Adapter	0.900Inches $\pm$ 0.010	0.910 0.890	0.896	Diameter
12	Adapter	0.500Inches $\pm$ 0.010	0.510 0.490	0.499 ⁵	Diameter
13	Adapter	0.390Inches $\pm$ 0.010	0.400 0.380	0.396	
14	Adapter	0.385Inches $\pm$ 0.010	0.395 0.375	0.393	Diameter
15	Adapter	0.630Inches $\pm$ 0.030	0.660 0.600	0.630	Radius
16	Adapter	0.130Inches $\pm$ 0.030	0.160 0.100	0.130	Radius
17	Adapter	0.020Inches $\pm$ 0.030	0.050 (0.010)	0.020	Radius

DJP 19-05-14

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					